

Date: Tuesday, 12/11/2007 10:25:58 AM
User: COSS Admin

Process Sheet

| | | | | | |
|-----------------------|--|-----------------------|------------------|----------------|----------|
| Customer | : CU-DAR001 Dart Helicopters Services | | Drawing Name | : PATIENT STOP | |
| Job Number | : 36243 | | Part Number | : D2492 | |
| Estimate Number | : 11490 | | Drawing Number | : D2492 REV F | |
| P.O. Number | : N/A | | Project Number | : N/A | |
| This Issue | : 12/11/2007 | S.O. No. : N/A | Drawing Revision | : F | |
| Prsht Rev. | : NC | | Material | : N/A | |
| First Issue | : 12/10/2007 | Type : MACHINED PARTS | Due Date | : 12/24/2007 | |
| Previous Run | : 25271 | | Qty: | 16 | Um: Each |
| Written By | <u>JLM</u> 07-12-11 | | | | |
| Checked & Approved By | | | | | |
| Comment | : Est. E 00.06.26 Removed P/O for powder coat EC Est Rev:F Now 6061-T6.06-06-23 JLM | | | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---|-----------------------|---|
| 1.0 | M6061T6S080 | 6061-T6 .080 Sheet |
| Comment: Qty.: 1.9140 sf(s)/Unit Total : 30.6247 sf(s) 6061-T6 .080 Sheet Material: 6061-T6 0.080" thick (M6061T62S.080) Batch <u>106320</u> <u>B</u> 07-12-11 | | |
| 2.0 | WATER JET | FLOW WATER JET |
| Comment: FLOW WATER JET 1-Cut as per Dwg D2492 Dwg Rev: <u>F</u> <u>B</u> 07-12-11 Prog Rev: <u>F</u> <u>B</u>  | | |
| 2-Deburr if necessary <u>H3</u> 07-12-11 | | |
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE <u>H3</u> 07-12-11 |
| Comment: INSPECT PARTS AS THEY COME OFF MACHINE | | |
| 4.0 | QC8 | SECOND CHECK  <u>5</u> 07-12-11 <u>V16</u> <u>counts</u> |
| Comment: SECOND CHECK | | |
| 5.0 | BRAKE NC | NC BRAKE  |
| Comment: NC BRAKE Deburr Form using Jig DT2492B <u>SAD</u> 08-01-03 <u>18</u> | | |

Date: Tuesday, 12/11/2007 10:25:59 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PATIENT STOP

Job Number: 36243

Part Number: D2492

Job Number:



Seq. #: Machine Or Operation:

Description:

6.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/01/08 x16

7.0 POWDER COATING



POWDER COATING

(alodine) M-f
Acidetch : Alkaline

08/01/08

x16

Comment: POWDER COATING

m 106379

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

BP

08-01-08

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-f 08/01/08

9.0 PACKAGING 1 PACKAGING RESOURCE #1



PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 189

AS 08/01/08 x16

10.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/01/08

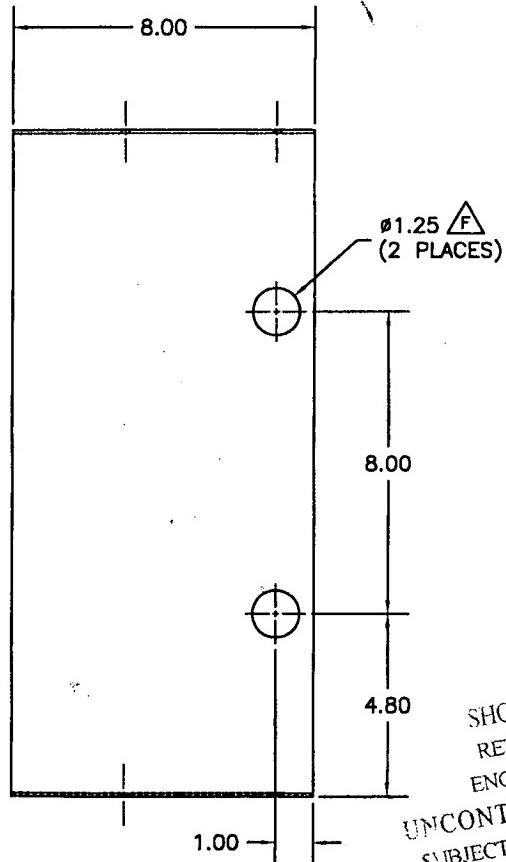
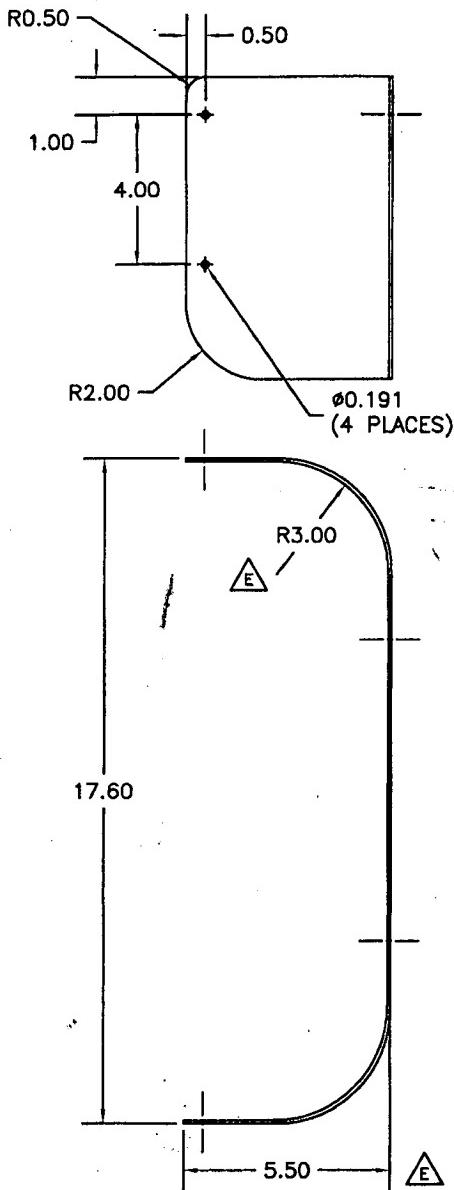
Job Completion



U 08-01-09

DART

| | | |
|----------------------|--------------------------------|---|
| DESIGN KE | DRAWN BY <i>[Signature]</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA |
| CHECKED <i>PH</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D2492 |
| DATE 06.09.14 | | REV. F SHEET 1 OF 1 TITLE PATIENT STOP SCALE 1:5 |
| A | 95.10.24 | NEW ISSUE |
| B | 96.02.28 | MINOR CHANGES |
| C | 97.07.14 | CHANGED MATERIAL AND FINISH |
| D | 98.05.11 | R4.00 WAS R2.00 ADDED 8" WIDTH DIMENSION |
| E | 06.05.30 | ADD 6061-T6 MATERIAL, R3.0 WAS R4.00, 5.50 WAS 6.00 |
| F | 06.09.14 | \varnothing 1.25 WAS \varnothing 1.020 |



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RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. *36243*

D2492 PATIENT STOP

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK
(REF DART SPEC M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005.4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

RELEASED

06.09.14

| | | |
|-----------------------------|--------------|-------------|
| DARIN AEROSPACE LTD | Work Order: | 36243 |
| Description: PATIENT STOP | Part Number: | D3492 |
| Inspection Dwg:D3492 Rev: F | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

| | | | | | |
|--------------|----------|-------------|----------|---------------------|----------|
| Measured by: | <u>B</u> | Audited by: | <u>J</u> | Prototype Approval: | <u>A</u> |
| Date: | 07-12-11 | Date: | 21/12/11 | Date: | 21/12/11 |

| Rev | Date | Change | Revised by | Approved |
|-----|------|-----------|------------|----------|
| A | | New Issue | KJ/JLM | |